

79171

January-23-12 10:43:54 AM

Accept

N900040100

Setup Start *NS1*

Stop ***NS2***

20

20

Reference:

Run Start *NR1*

Date:

Stop *NR2*

Date:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79171

79171

Page 2

January-23-12 10:43:54 AM

Item ID: D3393-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Battery Lock Casing
 Start Date: 23/01/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check 0.00

130

QC

Memo

0.00

Quality Control

Jan 12.02.27 20

140 Chemical Conversion Coat per QSI005 4.1 0.00

140

HandFinish

Memo

0.00

Hand Finishing

AB 12-2-27 (20)

150 Fire Red(Ref:4.3.5.10) per QSI005 4.3 0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME: *3:30* OVEN TEMPERATURE:

FINISH TIME:

3200F

4:00

20X M-12/02/28

M113645

W/O:		WORK ORDER CHANGES					
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 Required Date: 06/02/2012 Req'd Qty: 20.00 ***20*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

20 / 11/02/29

(20x) SP 12-02-29

MLJ 12/02/29

12-02-29
20

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Picklist Print

January-23-12 10:43:57 AM

Page 1

Work Order ID: 79171

79171

Parent Item: D3393-1

D3393-1

Parent Item Name: Battery Lock Casing

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.02.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.50 0		Purchased	No			100	f	11.1950	0.2708	5.701053			

M6061T6B1 500X01 500

6061-T6 Bar 1.50 x 1.50

** → /PO 12/02/25

Location

Loc Qty

Loc Code

MAT004

11.195

107432

1.1

118400

0.376

→ 119231

9.719

5.701053 FT

* MATERIAL IS NOT IN COMPUTER

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	79171
Description: Battery Lock Casing		Part Number:	D3393-1
Inspection Dwg: D3393 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+0.010/-0.000	Ø 0.754	✓		Vern	GA-01
0.625	+0.010/-0.000	0.632	✓		"	"
Ø1.250	+/-0.010	Ø 1.248	✓		"	"
1.088	+/-0.010	1.086	✓		"	"
Ø0.734	+/-0.010	Ø 0.736	✓		"	"
2.658	+/-0.010	2.655	✓		"	"
1.550	+/-0.010	1.550	✓		"	"
0.125 x 45°	+/-0.010 x 0.5°	0.120 x 45°	✓		"	"
1.50	+/-0.030	1.490	✓		"	"
0.750	+/-0.010	0.745	✓		"	"
Ø1.050	+/-0.010	Ø 1.052	✓		"	"
Ø1.000	+/-0.010	Ø 1.002	✓		"	"
0.338	+/-0.010	0.343	✓		D-6	GA-08
0.563	+/-0.010	0.565	✓		Vern	GA-01
0.100	+0.000/-0.010	0.096	✓		H-G	31006
3.00	+/-0.030	3.001	✓		Vern	GA-01
1.500	+/-0.010	1.500	✓		"	"
0.375	+/-0.010	0.375	✓		D-6	GA-08
1.25	+/-0.030	1.250	✓		Vern	GA-01
0.125	+/-0.010	0.120	✓		"	"
30°	0.5°	30°	✓		Angle meter	CNC-03

Measured by:	Y.A.	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	12/02/26	Date:	12-02-27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	
B	08.11.28	Tolerances revised	KJ/EC	<i>[Signature]</i>

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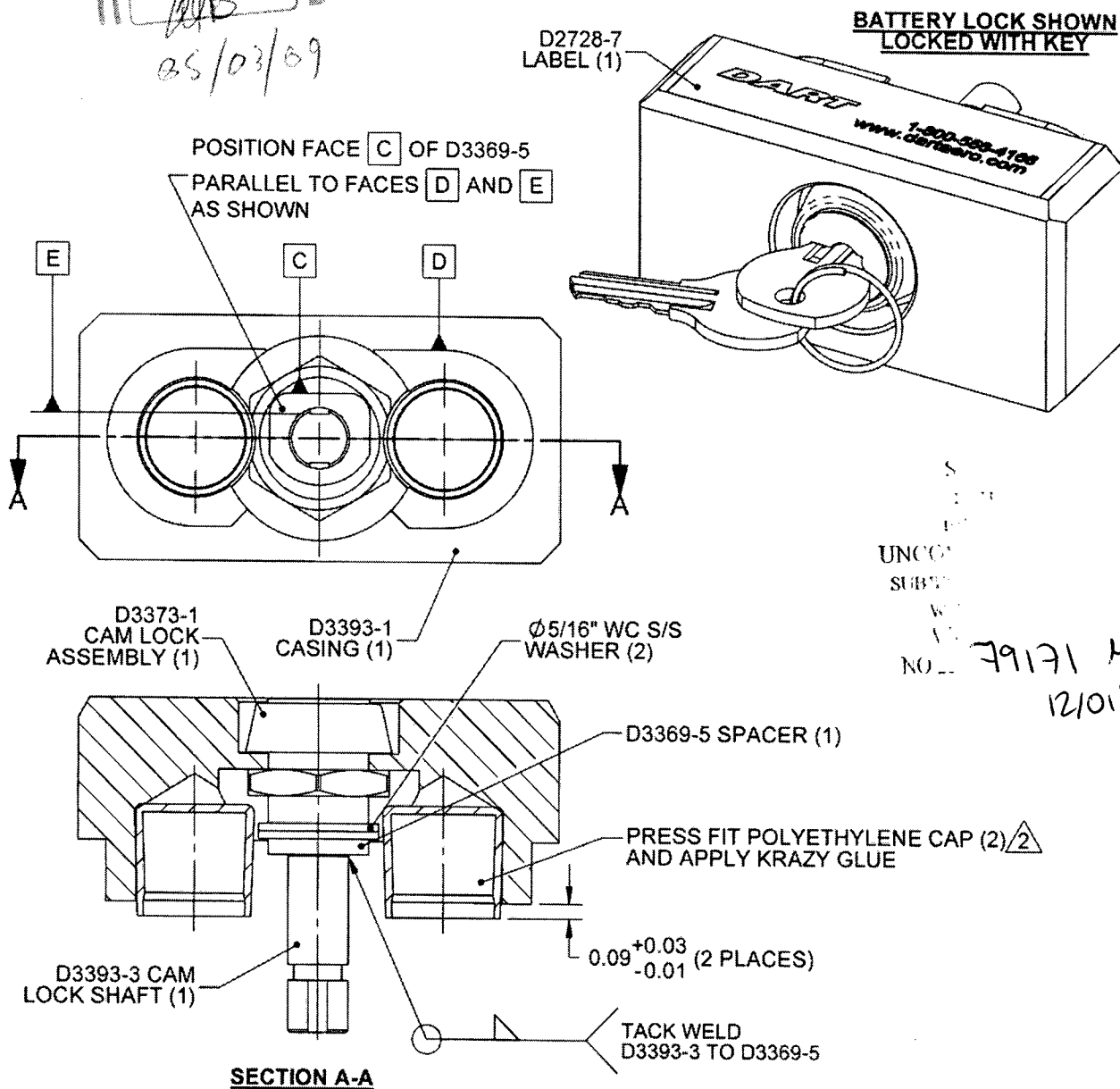
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DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED AKS	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
05/03/09



D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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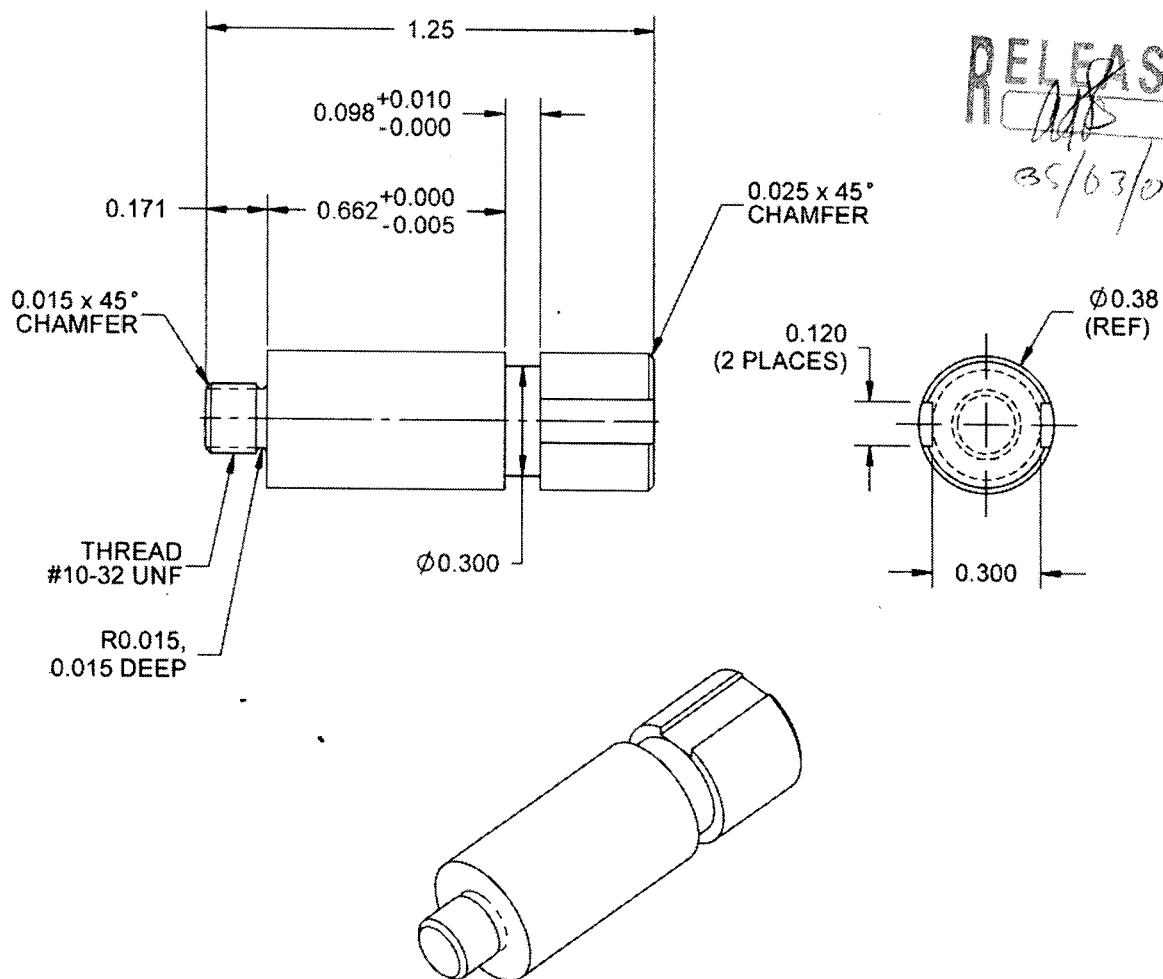
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79171

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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